

Work Order ID 95346

95346

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January-09-13 10:30:01 AM

Item ID: D3024-1

Revision ID:

Item Name: Spacer

Start Date: 1/09/13

Start Qty: 12.00 *12*

Required Date: 1/18/13

Req'd Qty: 12.00 *12*

Accept

N900040100

Setup Start

NS1

Stop

NS2

Reference:

Approvals:

Process Plan: ML5

Date: 13-01-10 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100	Rev A	0.00							
100	Hardinge CNC LATHE SMALL								
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	Turn blank as per Folio FA267 and Dwg D3024								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110	Memo	0.00							
QC									
Quality Control									
120	Small Fab	0.00							
120	Memo	0.00							
Small Fab	Deburr								
Small Fab									

13-1-16

13-1-16

13-1-16

DAS
13
8-89DAS
13
8-89DAS
13
8-89

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No. _____		Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>		Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
NCR No. _____		Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>		Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
		Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>		Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
		Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>		Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										
FAULT CATEGORY										
Landing Gear	General									
	<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized					<input type="checkbox"/> Pressure/Forced	
	<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance					<input type="checkbox"/> Temperature/Cure	
	<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect					<input type="checkbox"/> Weld	
	<input type="checkbox"/> Crushed/Crimped.	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing					<input type="checkbox"/> Wrong Stock Pulled	
	<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved						
	<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong						
	<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge						
	<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset							<input type="checkbox"/> Other
	<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration							
	<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence							
	<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions							

Work Order ID 95346

95346

Page 2

January-09-13 10:30:01 AM

Item ID: D3024-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Spacer

Stop

NS2

Start Date: 1/09/13

Start Qty: 12.00

12

Cust Item ID:

Required Date: 1/18/13

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan:

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

10AS
14
9-89

13/01/16

26 6

130

QC

Quality Control

140

Identify as per dwg & Stock Location:

ST624 0.00

0.00

140

Packaging

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

0.00

13/1/23

150

QC

Quality Control

130Kf

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
Bending	Bend	Grain	Ovalized	Pressure/Forced							
Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure							
Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld							
Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled							
Cuffs	Contamination	Maintenance	Part Moved								
Heat Treat	Countersink	Mislabeled	Positioned Wrong								
Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge								
Ripples in Bend	Drill Holes	Offset									
Torque Waves in Extrusion	Drawing	Out of Calibration									
Turning Sequence	Finish	Out of Sequence									
Wave/Twist in Tube	Folio	Outside Dimensions									

Picklist Print

January-09-13 10:30:01 AM

Page 1

Work Order ID: 95346

Parent Item: D3024-1

Parent Item Name: Spacer

Start Date: 1/09/13

Required Date: 1/18/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP B03.05.06Reformat; Made on CobraKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.375 303 Round Bar 0.375"		Purchased	No			100	f	36.6456	0.0729	0.9208416			

Location	Loc Qty	Loc Code
MAT028	36.6456	
115806	3.422	
115868	7.4196	
121157	25.804	

13-1-16 D
T.S. Dk

NCR: Yes / No

DQA: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework _____ Scrap _____ Use-as-is _____ Work Order Update _____		AGAINST DEPARTMENT/PROCESS Skid-tube _____ Machining _____ Thermoforming _____ Large Fab _____ Crosstube _____ Small Fab _____ Finishing _____ Composite _____ Water Jet _____ Prod. Eng. Coor. _____ Rec/Store/Packaging _____ Supplier _____							
Root Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector	
FAULT CATEGORY													
Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube				General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish Folio		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration Out of Sequence Outside Dimensions		Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled			
												<input type="checkbox"/> Other	

DART AEROSPACE LTD	Work Order:	95346
Description: Spacer	Part Number:	D3024-1
Inspection Dwg: D3024	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

DA

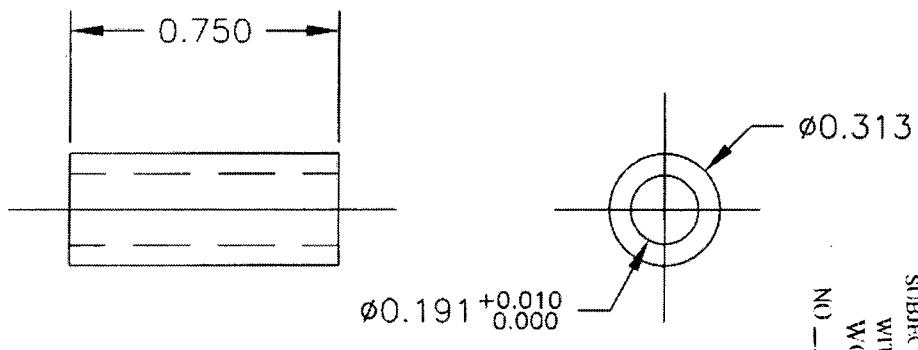
Measured by:	13/01/16	Audited by:	14/01/16	Prototype Approval:	N/A
Date:	13-1-16	Date:	13/01/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	<i>[Signature]</i>



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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3024	SHEET 1 OF 1
DATE		TITLE	SCALE
01.05.18		SPACER	2:1
A	01.05.18	NEW ISSUE	



UNCONTR.
SUBJECT 1
WITH
W/C
NO-95346/MC
(3-0-1-10)

D3024-1:

- 1) THIS PART CAN BE PROCURED AS FINISHED PART UNDER NAS43HT3-48 OR MANUFACTURED FROM D2835.
- 2) MATERIAL: AISI 303/304/316/416 STAINLESS STEEL BAR.
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

RELEASED
01.05.30 *[Signature]*

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